

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006704**Date Inspected:** 10-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-OBG Assembly

This QA Inspector randomly observed the following work in progress:

Magnetic Particle Testing (MT):

For Green Tag:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	FB 201-012	01,03,05,07,09,11	007143	9 D
2.	BP 206-012	002,004,006	007144	9 D
3.	BP 202-013	002,004,006	007141	10 A
4.	SP 208-012	002,004,006	007140	9 D
5.	SP 680-001	002,004,006	007142	11 AW

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

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Magnetic Particle Testing (MT):

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report on this date.

The member and the weld designations are as follows:

Sl #	Section #	Weld #	Green Tag #	Location
1.	WSD1 DPSA3-17	B/B-17,18,28	005848	NA
2.	NSD1 DPSA3-1	B/B-17,18,28	005847	NA

SMAW Process:

Welding of weld joints# B/B-8 located on PCMK SSD1 DPSA4-2. Welder is identified as 068088 & 037743. ZPMC QC is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joints# B/B-9 located on PCMK SSD1 DPSA4-2. Welder is identified as 037779 & 066481. ZPMC QC is identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

FCAW Process:

Welding of weld joints# 1A,8A located on PCMK SSD1 DPSA4-16. Welder is identified as 067601. ZPMC QC is identified as Wang Sun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3-F.

Welding of weld joints# 4A,5A located on PCMK SSD1 DPSA4-16. Welder is identified as 066687. ZPMC QC is identified as Wang Sun. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2233-B-U3-F.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 1&2 located on PCMK SP 204-014. Welder is identified as 051246. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 9&10 located on PCMK SP 204-014. Welder is identified as 202841. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 5&6 located on PCMK SP 204-014. Welder is identified as 20. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Bay# 5-OBG Assembly

This QA Inspector randomly observed the following work in progress:

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Final VT:

This QA inspector performed Final Visual Testing (FVT) of entire welded area of 5 no, miscellaneous items PCMK CTS 1D1, previously tested and accepted by ZPMC Quality Control personnel.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
